

NS1

NS?

Item Name: Floor Window Close Out (AS350 B3e)

1

Cust Item ID:

1

Customer:

Reference:

Date:

NR1

Date:

NR2

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By																																																									
								Lead hand / Supervisor Approval Verification																																																									
								QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐																																																																

Thursday, February 16, 2017 11:12:15 AM

157173

Page 2

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 2/17/2017 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 2/24/2017 **Req'd Qty:** 1.00 ***1***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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0.00

130

Packaging

0.00

Packaging

Packaging

Memo

Identify and pack for shipping as per PPP D350-567-145
Location:FG033

**DAS
28
9-89**

FEB 24 2017

0.00

140

QC21- Final Inspection - Work Order Release

0.02

QC

Quality Control

Memo

FEB 24 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Picklist Print

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Page 1

Work Order ID: 157173

157173

Parent Item: D350-567-145

D350-567-145

Parent Item Name: Floor Window Close Out (AS350 B3e)

Start Date: 2/17/2017

Required Date: 2/24/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 13.04.01 AS PER DSI9590 REV.E DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
CB200 *CB200* Acrylic Adhesive, 3.5G		Purchased	No			110	Each	9.0000	1	1			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				PKG				9					
				m136020				9					
D4730-020-030 *D4730-020-030* Velcro Strip 2.0W/ X 3.0L		Manufactured	No			110	Each	7.0000	1	1			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST122				7					
				156035				7					
D4971-041 *D4971-041* T/R Bellcrank Cover Assembly		Manufactured	No			110	Each	3.0000	1	1			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST621				3					
				156583				3					
D5076-041 *D5076-041* Fwd Bracket Assembly		Manufactured	No			110	Each	1.0000	1	1			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST617				1					
				155880				1					

DAS 28 9-89

FEB 23 2017

DAS 26 9-89

DAS 28 9-89

FEB 23 2017

DAS 26 9-89

DAS 28 9-89

FEB 23 2017

DAS 26 9-89

DAS 28 9-89

FEB 23 2017

DAS 26 9-89

DAS 28 9-89

FEB 23 2017

DAS 26 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
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				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Picklist Print

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Page 2

Work Order ID: 157173

157173

Parent Item: D350-567-145

D350-567-145

Parent Item Name: Floor Window Close Out (AS350 B3e)

Start Date: 2/17/2017

Required Date: 2/24/2017

Start Qty: 1.00

Required Qty: 1.00

D3802-1 Manufactured No

110 f

72.3158

2 2

D3802-1

Window Seal (\$ per foot)

DAS
28
9-89

Location

Loc Qty

Loc Code

ST416

72.31578947

147067

4

153922

18.3157895

156349

50

FEB 23 2017

DAS
26
9-89

(D3802-1-024) CUT (1) AT 24" AS PER DWG, PER KIT.

D4435-9

Manufactured No

110

Each

0.0000

2 2

D4435-9

Bracket

DAS
28
9-89

D4436-041

Manufactured No

110

Each

0.0000

1 1

D4436-041

Aft Bracket Assembly

DAS
28
9-89

D4441-1

Manufactured No

110

f

363.4920

2 2

D4441-1

Rubber Seal

DAS
28
9-89

Location

Loc Qty

Loc Code

ST422

114.112

151347

114.112

ST625

249.38

151347

249.38

FEB 23 2017

DAS
26
9-89

(D4441-1-240) CUT (1) AT 24.00" PER KIT

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
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Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : ☐			

Picklist Print

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Work Order ID: 157173

157173

Parent Item: D350-567-145

D350-567-145

Parent Item Name: Floor Window Close Out (AS350 B3e)

Start Date: 2/17/2017

Required Date: 2/24/2017

Start Qty: 1.00

Required Qty: 1.00

AN3-3A
Bolt
AN3-3A

Purchased No

110 Each

159.0000

5 5

**

DAS
6
9-89

FEB 23 2017

DAS
26
9-89

Location

Loc Qty

Loc Code

over003

50

m136851

50

ST350

109

m136643

9

m136741

100

AN525-10R6
Screw
AN525-10R6

Purchased No

110 Each

184.0000

2 2

**

DAS
6
9-89

FEB 23 2017

DAS
26
9-89

Location

Loc Qty

Loc Code

ST329

184

M134502

184

AN525-832R7
Screw
AN525-832R7

Purchased No

110 Each

33.0000

2 2

**

DAS
6
9-89

FEB 23 2017

DAS
26
9-89

Location

Loc Qty

Loc Code

GA

31

m136147

31

ST328

2

m134070

2

MS21042L06
Nut
MS21042L06

Purchased No

110 Each

165.0000

7 7

**

DAS
6
9-89

FEB 23 2017

DAS
26
9-89

Location

Loc Qty

Loc Code

ST303

165

m136643

65

m136741

100

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Shop Packet Print

Page 3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Picklist Print

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Page 4

Work Order ID: 157173

157173

Parent Item: D350-567-145

D350-567-145

Parent Item Name: Floor Window Close Out (AS350 B3e)

Start Date: 2/17/2017

Required Date: 2/24/2017

Start Qty: 1.00

Required Qty: 1.00

MS21042L08

Purchased

No

110

Each

876.0000

2

2

MS21042L08

Nut

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

503

m135274

18

m135978

485

ST303

373

m136643

160

m136851

213

MS21042L3

Purchased

No

110

Each

2,310.000

5

5

MS21042L3

Nut

DAS
28
9-89

Location

Loc Qty

Loc Code

FP001

100

m135945

100

GA

146

m134360

108

m135135

38

OVER007

500

m134360

0

M136665

500

ST303

564

M136406

64

M136554

500

ST3030

1000

M136838

1000

DAS
6
9-89

FEB 23 2017

DAS
26
9-89

DAS
6
9-89

FEB 23 2017

DAS
26
9-89

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Description Work Order Deviation				Disposition				Completed By	
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Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
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Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

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Work Order ID: 157173

157173

Parent Item: D350-567-145

D350-567-145

Parent Item Name: Floor Window Close Out (AS350 B3e)

Start Date: 2/17/2017

Required Date: 2/24/2017

Start Qty: 1.00

Required Qty: 1.00

MS21059L3 Purchased No

110 Each

134.0000

2 2

MS21059L3

Nut Plate

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

25

M136047

25

ST301

109

M136450

44

M136835

65

**

DAS
6
9-89
FEB 23 2017

DAS
26
9-89

MS35206-229 Purchased No

110 Each

263.0000

7 7

MS35206-229

Screw

DAS
28
9-89

Location

Loc Qty

Loc Code

ST271

263

M135603

263

**

FEB 23 2017

DAS
26
9-89

NAS1149F0332P Purchased No

110 Each

3,209.000

10 10

NAS1149F0332P

Washer

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

335

m133709

335

ST260a

1800

m136835

1800

ST262

1074

m136442

1074

**

DAS
6
9-89

FEB 23 2017

DAS
26
9-89

Thursday, February 16, 2017 11:12:20 AM

Shop Packet Print

Page 5

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : ☐			

Picklist Print

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Work Order ID: 157173

157173

Parent Item: D350-567-145

D350-567-145

Parent Item Name: Floor Window Close Out (AS350 B3e)

Start Date: 2/17/2017

Required Date: 2/24/2017

Start Qty: 1.00

Required Qty: 1.00

NAS1149FN616P

Purchased

No

110

Each

118.0000

14

14

NAS1149FN616P

WASHER

DAS
28
9-89

Location

Loc Qty

Loc Code

ST264

118

M136199

18

M136741

100

NAS1149FN816P

Purchased

No

110

Each

382.0000

2

2

NAS1149FN816P

WASHER

DAS
28
9-89

Location

Loc Qty

Loc Code

ST263

382

117316

382

DAS
26
9-89

DAS
6
9-89

FEB 23 2017

FEB 2 2017

DAS
6
9-89

DAS
26
9-89

Thursday, February 16, 2017 11:12:20 AM

Shop Packet Print

Page 6

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐				
Date : _____	Step #: _____	QTY Effective : _____			MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			Completed By	
					Lead hand / Supervisor Approval Verification	
					QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
OTHER : _____						

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D412-761 REV. D OR EARLIER AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D412-761 REV. 1 OR EARLIER

REF. TCCA STC: SH09-4

REF. EASA STC: 10028917

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WORK ORDER

PURPOSE

THE PURPOSE OF THIS SERVICE INSTRUCTION IS TO INTRODUCE THE ALTERNATE D412-761-051 ARMREST KIT FOR D412-761-041 FULL VERTICAL REFERENCE DOOR KIT. IN COMPARISON WITH THE STANDARD D412-761-049 ARMREST KIT, THE ALTERNATE D412-761-051 ARMREST KIT FEATURES AN ELONGATED AND NARROWER ARMREST CUSHION.

FEB 16 2017

REFER TO SHEET 2 FOR THE ALTERNATE D412-761-051 ARMREST KIT PARTS LIST.

INSTALLATION

THE INSTALLATION OF D412-761-051 ARMREST KIT IS SAME AS D412-761-049 ARMREST KIT. PERFORM INSTALLATION PER IIN-D412-761 AND INSTALLATION DRAWING D412-761-3 BY SUBSTITUTING D3780-041 ARMREST ASSEMBLY WITH D4097-041 ARMREST ASSEMBLY.

KIT CONVERSION

CUSTOMERS WHO ALREADY HAVE THE D412-761-049 ARMREST KIT INSTALLED AND WOULD PREFER THE NEW D412-761-051 ARMREST INSTALLATION MAY SUBSTITUTE THEIR EXISTING D3780-041 ARMREST ASSEMBLY WITH D4097-041 ARMREST ASSEMBLY. SIMILARLY, CUSTOMERS WHO HAVE INSTALLED THE NEW D412-761-051 ARMREST KIT AND WOULD LIKE TO CONVERT THEIR EXISTING KIT INTO A D412-761-049 MAY DO SO BY SUBSTITUTING THE D4097-041 ARMREST ASSEMBLY WITH THE D3780-041 ARMREST ASSEMBLY. REFER TO SECTION 52.5 OF ICA-D412-761, SECTION 3.3 OF IIN-D412-761 AND DRAWING D412-761-3. ADJUST WEIGHT AND BALANCE PER THE TABLE BELOW.

WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D412-761-041 Full Vertical Reference Door Kit (includes -045/-047/-049 Kits)	27.9 lb 12.6 kg	-46.5 in -1.18 m	-1297 lb-in -14.9 kg-m	47.9 in 1.22 m	1336 lb-in 15.4 kg-m
D412-761-041A Full Vertical Reference Door Kit (includes -045/-047/-051 Kits)	26.9 lb 12.2 kg	-46.5 in -1.18 m	-1251 lb-in -14.4 kg-m	47.9 in 1.22 m	1289 lb-in 14.9 kg-m
D412-761-045 Bubble Window/Modified Latch Mechanism Kits	16.0 lb 7.26 kg	-47.8 in -1.21 m	-764.8 lb-in -8.78 kg-m	47.0 in 1.19 m	752.0 lb-in 8.64 kg-m
D412-761-047 Door Mounted Instrument Panel Kit (Excludes Instruments)	3.8 lb 1.70 kg	-42.8 in -1.09 m	-160.5 lb-in -1.85 kg-m	39.2 in 1.00 m	147.0 lb-in 1.70 kg-m
D412-761-049 Armrest Kit	7.3 lb 3.31 kg	-37.1 in -0.94 m	-270.8 lb-in -3.11 kg-m	61.4 in 1.56 m	448.2 lb-in 5.16 kg-m
D412-761-051 Alternate Armrest Kit	6.3 lb 2.86 kg	-37.1 in -0.94 m	-233.7 lb-in -2.69 kg-m	61.4 in 1.56 m	386.8 lb-in 4.46 kg-m

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: D. SHEPHERD (DE # 02)

DATE: 10.05.10

CERT. NO.: SH09-4

ISSUE NO.: 2

A	NEW ISSUE	MB	10.05.10
REV.	DESCRIPTION	BY	DATE
DESIGN	<u>1</u>	DART AEROSPACE LTD	
DRAWN	<u>1</u>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<u>9</u>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9520	SHEET 1 OF 3
APPROVED	<u>10</u>	TITLE	SCALE
DE APPR.	<u>11</u>	ALTERNATE ARMREST INSTALL	NTS
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PARTS LIST

QTY -051	PART NUMBER	DESCRIPTION
X	D412-761-051	ARMREST KIT, LH
1	D3694-041	MOUNTING PLATE ASSEMBLY
1	D3694-1	* KEYWAY
1	D3694-3	* PROTECTIVE PLATE
1	D3694-5	* MOUNTING PLATE
1	AN526C1032R8	* SCREW
5	AN960JD10	* WASHER
4	MS21042L3	* NUT
2	MS21209F1-20	* HELI-COIL, SCREW LOCKING (RED)
1	MS24693-C271	* SCREW (OR MS24693-S271)
4	MS24693-C273	* SCREW (OR MS24693-S273)
1	D3695-041	SLIDER ASSEMBLY
1	D3695-1	* SLIDER
1	D3695-3	* STOPPER
1	D3801-1	* HAND RETRACTABLE SPRING PLUNGER
1	MS21209F6-25	* HELI-COIL, SCREW LOCKING (RED)
4	MS21209F1-20	* HELI-COIL, SCREW LOCKING (RED)
4	MS24693-C276	* SCREW (OR MS24693-S276)
1	D4097-041	ARMREST ASSEMBLY
1	D3696-041	* ARM ASSEMBLY
1	D3696-1	** ARM
1	D3801-3	** HAND RETRACTABLE SPRING PLUNGER
1	D4098-041	* CUSHION ASSEMBLY
1	D4099-1	* BRACKET
3	MS21042L3	* NUT
5	MS24693-C273	* SCREW
3	MS24693-C277	* SCREW
3	NAS1149D0332J	* WASHER
11	AN3-6A	BOLT
1	AN6-26	BOLT
1	AN310-6	CASTELLATED NUT
11	AN960JD10	WASHER
1	AN960JD616L	WASHER
2	NAS1515H6L	WASHER
1	MS24665-302	COTTER PIN
3	MS21071L3	ANCHORNUT
8	MS21075L3	NUTPLATE

* DENOTES PART IS INCLUDED WITH ASSEMBLY ABOVE
** DENOTES PART IS INCLUDED WITH ASSEMBLY ABOVE

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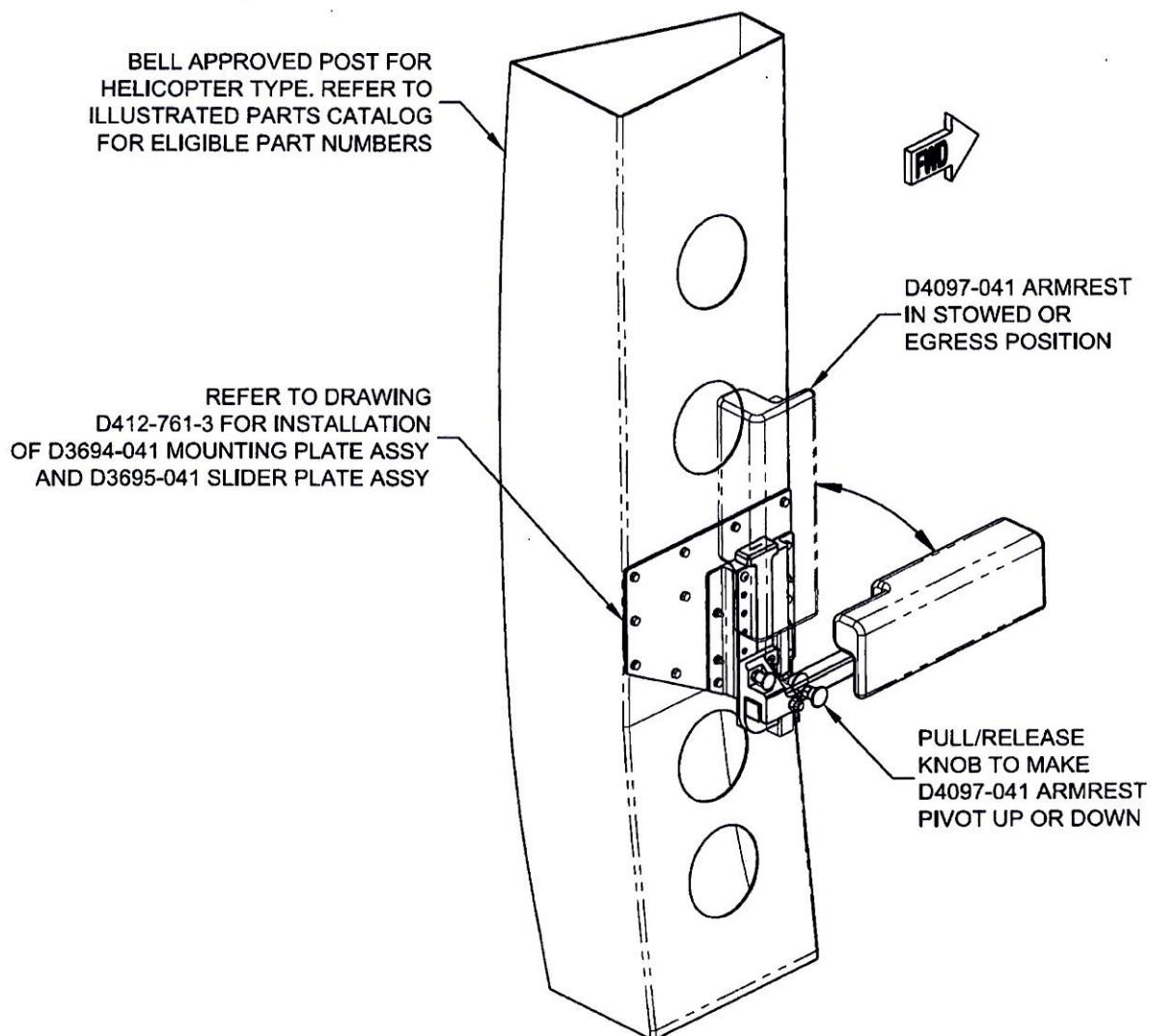


FIGURE 1: D412-761-051 ARMREST INSTALL OVERVIEW

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REFERENCE ONLY

2.0 Parts List

Qty -141	Qty -143	Qty -145	Part Number	Description
X			D350-567-141	FLOOR WINDOW CLOSE-OUT KIT (REGULAR SEATS)
	X		D350-567-143	FLOOR WINDOW CLOSE-OUT KIT (ENERGY ATTENUATING SEATS)
		X	D350-567-145	FLOOR WINDOW CLOSE-OUT KIT (AS 350 B3e)
1	1	1	D3802-1-024	SEAL (24")
1	1		D4434-041	FWD BRACKET ASSEMBLY
1	1		D4434-047	COVER ASSEMBLY
1			D4435-045	T/R BELLCRANK COVER ASSEMBLY
2	2	2	D4435-9	BRACKET
1	1	1	D4436-041	AFT BRACKET ASSEMBLY
1	1	1	D4441-1-240	RUBBER SEAL (24")
		1	D4730-020-030	VELCRO STRIP
	1	1	D4971-041	T/R BELLCRANK COVER ASSEMBLY
		1	D5076-041	FWD BRACKET ASSEMBLY
7	5	5	AN3-3A	BOLT
2	2	2	AN525-10R6	SCREW
2	2	2	AN525-832R7	SCREW
		1	CB 200	3.5g ACRYLIC ADHESIVE
7	7	7	MS21042L06	NUT (OR MS21042-06)
2	2	2	MS21042L08	NUT (OR MS21042-08)
5	5	5	MS21042L3	NUT (OR MS21042-3)
2	2	2	MS21059L3	NUTPLATE
7	7	7	MS35206-229	SCREW
12	10	10	NAS1149F0332P	WASHER (AN960-10L)
14	14	14	NAS1149FN616P	WASHER (OR AN960-6L)
2	2	2	NAS1149FN816P	WASHER (OR AN960-8L)

3.0 Weight and Balance

The following is the net weight increase associated with the D350-567-141/-143/-145 Kits.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-567-141/-143/-145 Floor Window Close-out Kit	3.9 lb 1.77 kg	17.9 in 0.45 m	69.8 in-lb 0.80 m-kG	65.5 in 1.66 m	255.5 in-lb 2.94 m-kG

4.0 Installation Procedure

Notes:

- Figure 2 shows the general arrangement and installation of the D350-567-141/-143/-145 Close-out Kits. The procedure that follows outlines the step-by-step procedures for installing the kit with reference photos from the initial installation.
- In conjunction with this modification, it is acceptable to remove the interior floor windows as applicable. Note that the structural reinforcement around the window opening is still required.
 - D350-567-115 - OK to remove D3295-041
 - D350-567-031 - OK to remove D3212-1
 - D350-567-011 - OK to remove D2214
 - D350-567-021 - OK to remove D2951
- It is acceptable to drill/trim the D350-567-141/-143/-145 Close-out Kits as required to improve fit.

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BY: *D. Shepherd*
D. SHEPHERD (DE # 02)

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